

Work Order ID 54555

December 11, 2009 1:42:07 PM

HA1



Item ID: d3608-3F

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Doubler

Start Date: 12/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608 : Dwg Rev: A : Prog Rev: A : 12-
Deburr if necessary

B 9-12-16

304.040

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-12-16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) Serial 1217

②

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Page 2

Item ID: d3608-3F

Accept



Setup Start



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Stop



Start Date: 12/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Packaging

*WAI 00700
S2M*

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

9/12/17

SL



09/12/22

W-2.122

Picklist Print

December 11, 2009 1:42:06 PM

Page 1

Work Order ID: 54555

Parent Item: d3608-3F

Parent Item Name: Upper Doubler

Comments:

Start Date: 12/14/09

Required Date: 12/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

306.3536

0.7781



304/316 .040 Sheet



B9-12-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

306.3536158

110076

1.37053684

112567

38.0765789

112885

83.1578

113062

166.3723

113077

17.3764

113077

①

DART AEROSPACE LTD		Work Order: 54555
Description: Upper Doubler		Part Number: D3608-3
Inspection Dwg: D3608	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	*			
0.500	+/-0.010	.502	*			
1.820	+/-0.010	1.817	*			
7.950	+/-0.010	7.949	*			
11.50	+/-0.030	11.50	*			
2.25	+/-0.030	2.257	*			
2.28	+/-0.030	2.285	*			
2.000	+/-0.010	2.007	*			
1.325	+/-0.010	1.324	*			
3.750	+/-0.010	3.750	*			
1.250	+/-0.010	1.250	*			
8.50	+/-0.030	8.501	*			
11.63	+/-0.030	11.617	*			
7.008	+/-0.010	7.010	*			
6.946	+/-0.010	6.941	*			
2.46	+/-0.030	2.467	*			
2.282	+/-0.010	2.283	*			
1.406	+/-0.010	1.406	*			
8.56	+/-0.030	8.558	*			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-12-16	Date: 09/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	

8 7 6 5 4 3 2 1

D

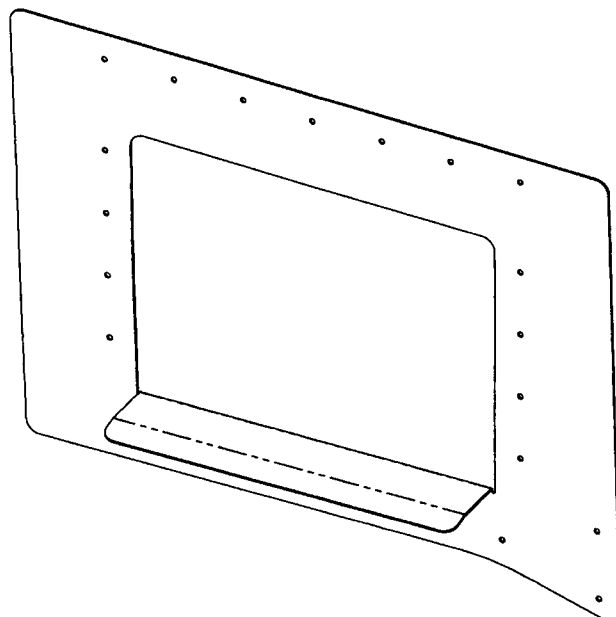
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C

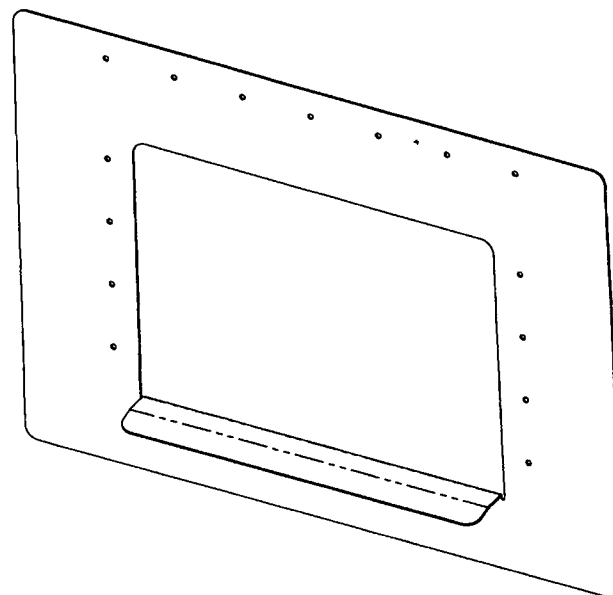
C

B

B



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

*ulb
5155g*

RELEASED
08/12/10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs EACH

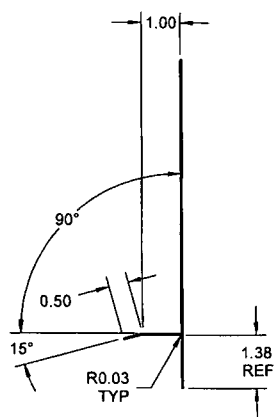
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DE APPR.				
DATE	07.04.11			

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TITLE DOUBLER	SCALE NTS

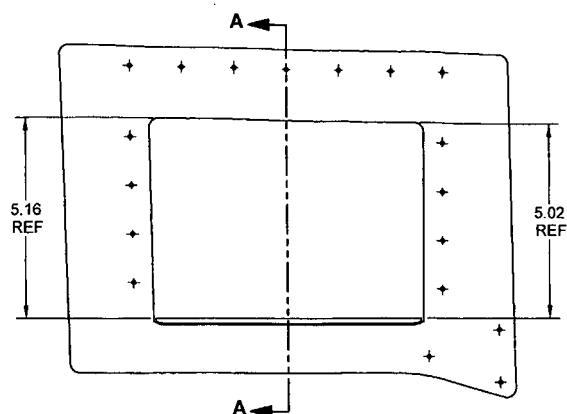
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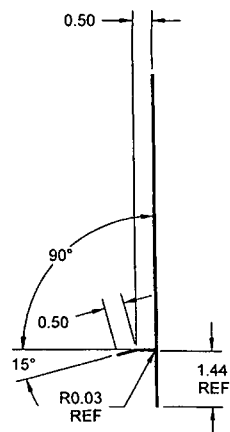
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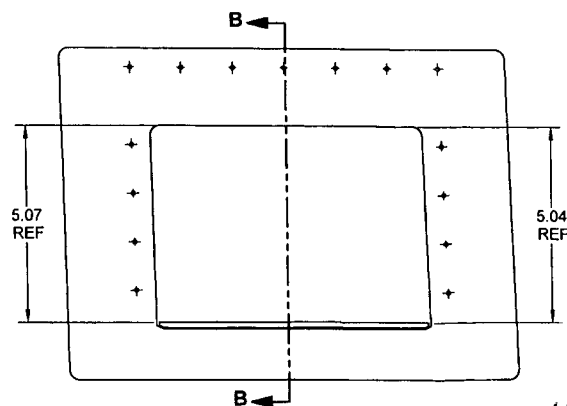
SECTION A-A



D3608-1 LOWER DOUBLER
(MAKE FROM D3608-1F)



SECTION B-B



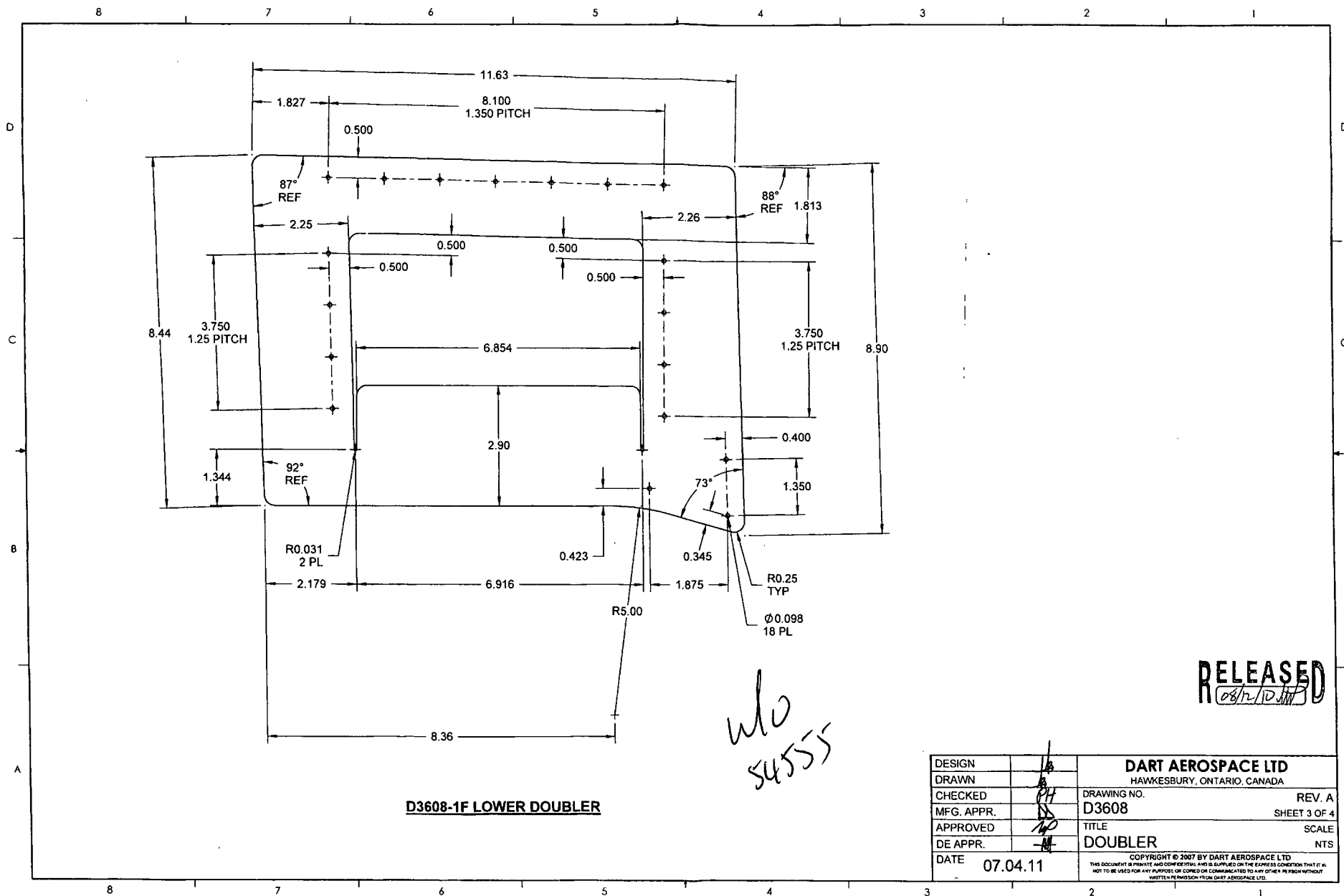
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(MAKE FROM D3608-3F)

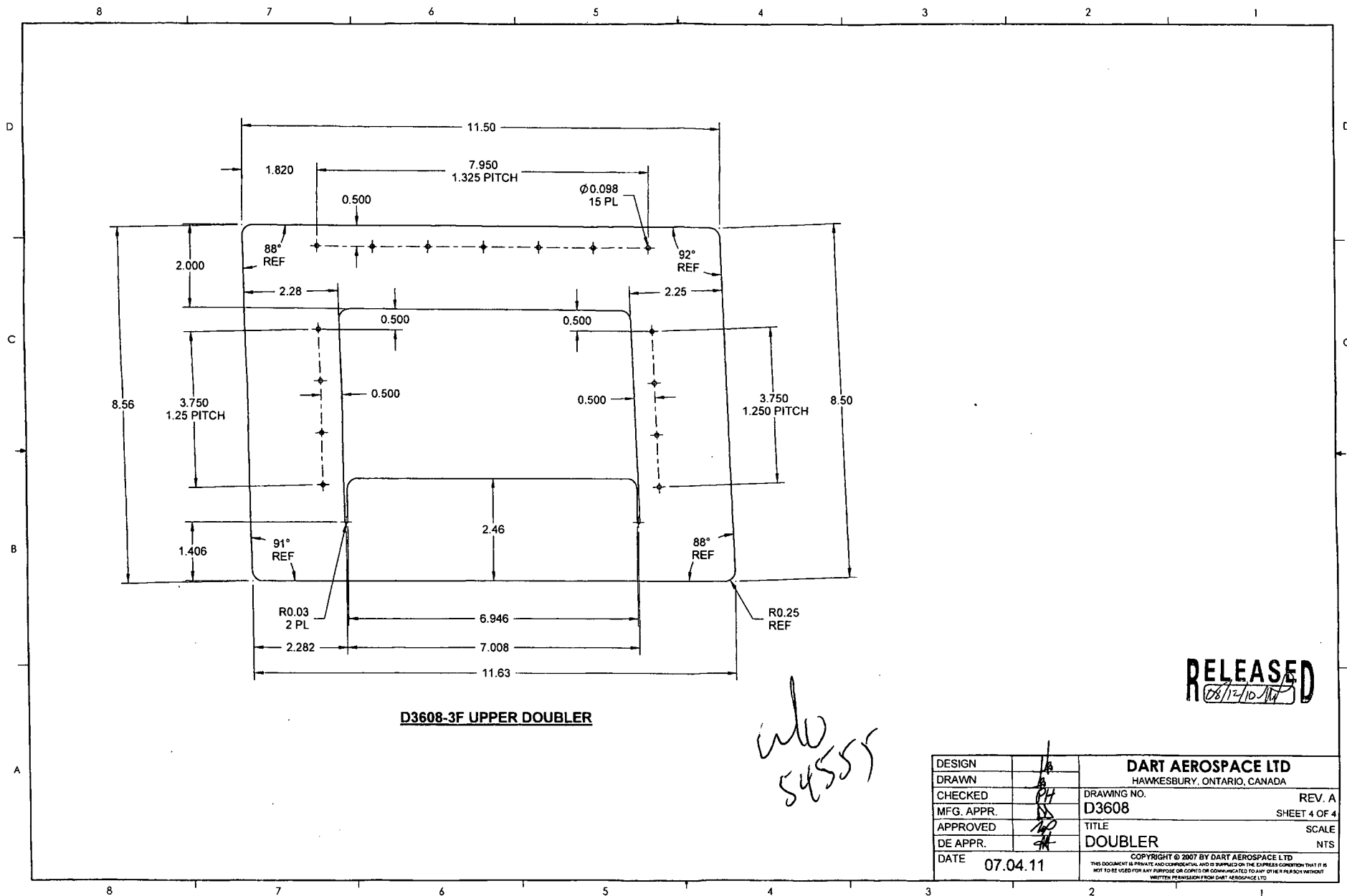
*WLS
54555*

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08/12/10 NW

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